

Work Order ID 141999

Tuesday, February 23, 2016 11:24:48 AM

141999

Page 1

Item ID: D3484-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tail Light Fairing Assembly, LH

Start Date: 2/23/2016 Start Qty: 5.00

Required Date: 3/11/2016 Req'd Qty: 5.00

Reference:

10
FEB 24 2016
5
DAS
13
9-89
5

Cust Item ID:

Customer:

Approvals:

Process Plan: MLSDate: FEB 23 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3484

Rev F

100

0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 31473

Make as per Dwg D3484

Material release note is required

10 FEB 24 2016

DAS
13
9-89

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

10x 8216-03-31

115

Weld per dwg A/R Aluminum rod Batch:

0.00

115

Large Fab

Memo

DAS
9
9-89

0.00

Large Fab

Touch up weld if necessary

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 141999

Tuesday, February 23, 2016 11:24:49 AM

141999

Page 2

Item ID: D3484-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tail Light Fairing Assembly, LH

Start Date: 2/23/2016 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 3/11/2016 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

(10)

16-04-04

DAS

9

9-89

130

QC6- Inspect dimensions to drawing

0.00

130

QC

Memo

0.00

Quality Control

(10)

16-04-04

DAS

9

9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

10x of 16/04/05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge
☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier
☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due
☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat
☐ Wave/Twist in Tube	☐ Marks/Chatter	☐ Temperature/Cure	☐ Set-up	☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination
☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes	☐ Power Loss/Surge	☐ Folio/Program	☐ Grain	☐ Weld
☐ Wrong Stock Pulled	☐ Out of Sequence	☐ Off-set	☐ Mislabeled	☐ Fit/Function	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions
☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
☐ OTHER : _____							

Work Order ID 141999

Tuesday, February 23, 2016 11:24:49 AM

141999

Page 3

Item ID: D3484-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tail Light Fairing Assembly, LH

Start Date: 2/23/2016 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 3/11/2016 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

10 FF APR 21 2016

160

0.00

160

Small Fab

Memo

0.01

Small Fab

1-Install Nut Plates as per Dwg D3484

10 FF APR 21 2016

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

(10) 38 9-89
APR 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 141999

Tuesday, February 23, 2016 11:24:49 AM

141999

Page 4

Item ID: D3484-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tail Light Fairing Assembly, LH

Start Date: 2/23/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 3/11/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00

200

Packaging

Memo

0.00

Packaging

Identify as per dwg and Stock
Location: Sts0210**APR 22 2016**DAG69-89

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.01

Quality Control

ML5**APR 22 2016**ML5**APR 22 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

Picklist Print

Tuesday, February 23, 2016 11:24:53 AM

Page 1

Work Order ID: 141999

141999

Parent Item: D3484-041

D3484-041

Parent Item Name: Tail Light Fairing Assembly, LH

Start Date: 2/23/2016

Required Date: 3/11/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 06-04-11 JLM
IPP Rev:B 08-01-24 chg rivet to CR1122-3-025 DD verf:EC IPP Rev:C
11.03.07 added weld touch up DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3484-041P		Purchased	No			110	Each	0.0000	1	510			
D3484-041P									**				
Tail light Fairing										110		8D1603-31	
MS21069-04		Purchased	No			160	Each	33.0000	2	10			
MS21069-04									**			FF	APR 21 2016
ANCHOR NUT													
Location ST299 m132067 Loc Qty 33 33 Loc Code													
CR1122-3-02.5		Purchased	No			160	Each	278.0000	4	20			
CR1122-3-02 5									**			FF	APR 21 2016
RIVET													
Location GA m132708 m133810 Loc Qty 278 78 200 Loc Code													
										40			

DQA: _____ Date: _____

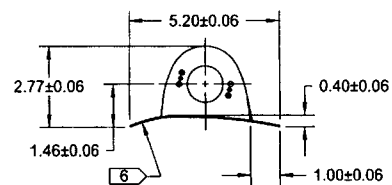
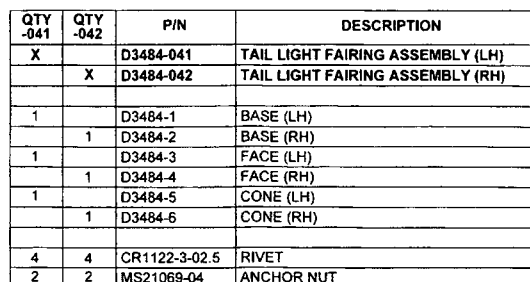


WORK ORDER NON-CONFORMANCE / UPDATE

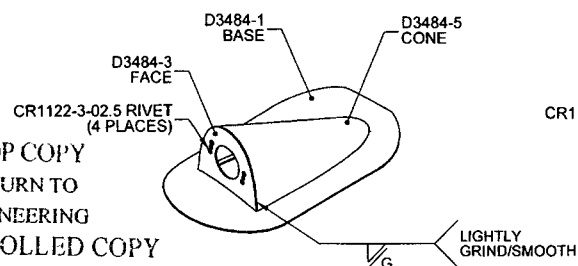
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



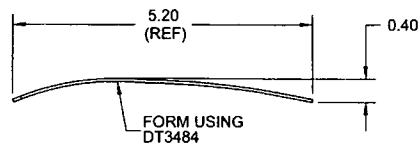
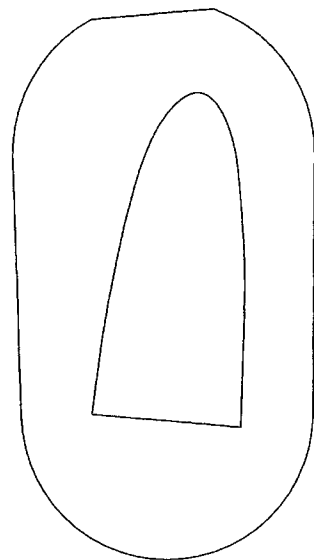
D3484-041 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW

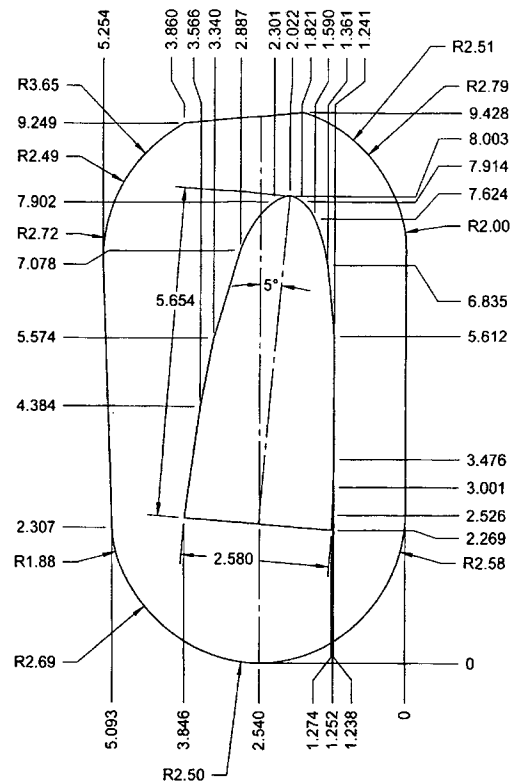
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

F	UPDATE MATERIAL SPEC. ADD 6061-0, ZN A7-2, A7-3, B3-4. UPDATE DIMENSIONS ZN C1-1, C2-1, C7-1, C8-1 UPDATE WELDING NOTE ZN A3-1, A6-1	09.03.31
E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY. CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS); DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20246AD3-3 RIVET	08.01.03
D	CORRECT D3484-1F	06.08.22
C	RE-DESIGN D3484-3F/5F	06.04.20
B	RE-DESIGN	06.02.21
A	NEW ISSUE	05.11.29
REV.	DESCRIPTION	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3484 TITLE TAIL LIGHT FAIRING COPYRIGHT © 2025 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO REUSE, REPRODUCTION OR DISSEMINATION OF THIS IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PARTY WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.31	

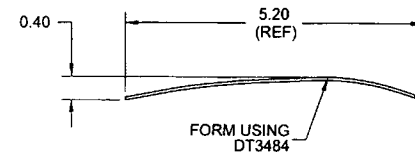
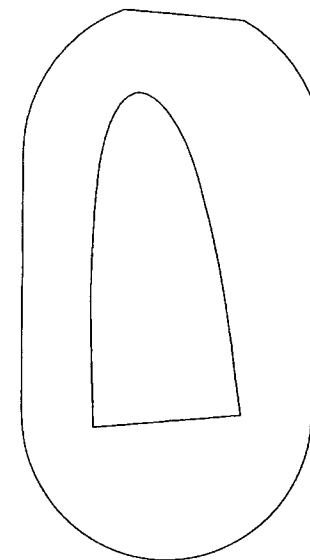


D3484-1 BASE
(MAKE FROM D3484-1F)

- NOTES:**
- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.16 lbs



D3484-1F BASE FLAT PATTERN

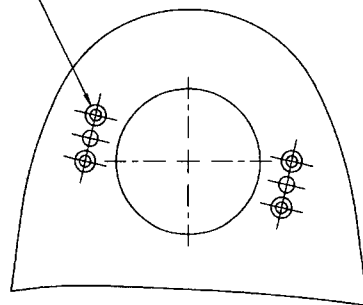


D3484-2 BASE
(MAKE FROM D3484-1F)

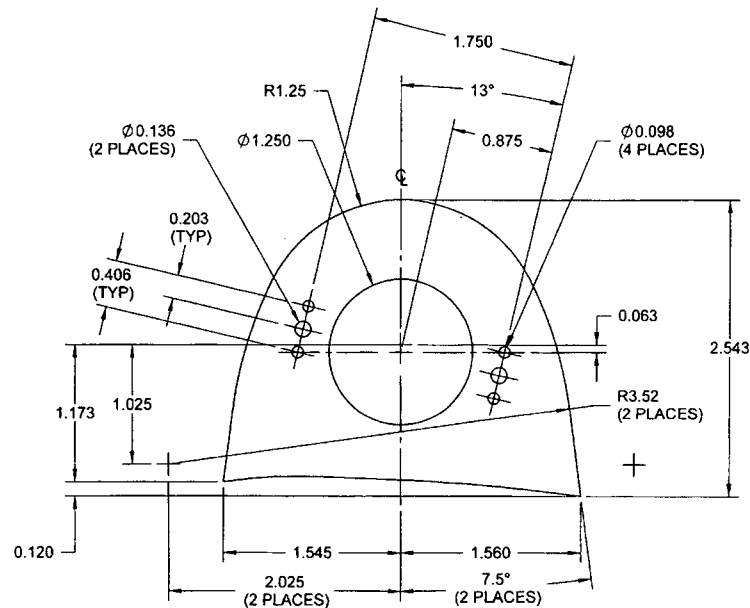
RELEASED
09/03/31

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3484	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:2
DATE	09.03.31	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

C'SINK
Ø0.181 X 100°
(4 PLACES)

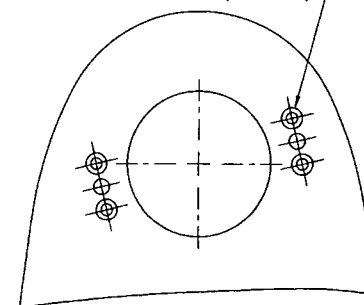


D3484-3 FACE
(MAKE FROM D3484-3F)



D3484-3F FLAT PATTERN TAIL LIGHT FAIRING

C'SINK
Ø0.181 X 100°
(4 PLACES)



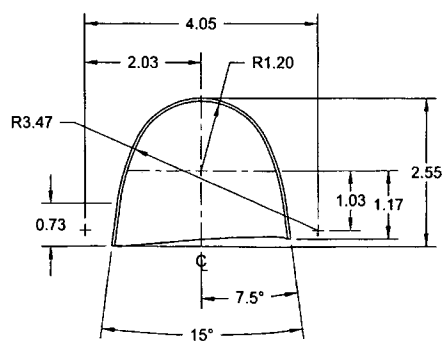
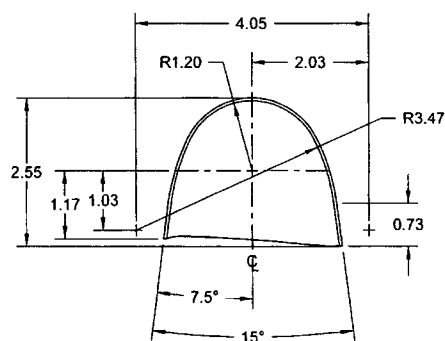
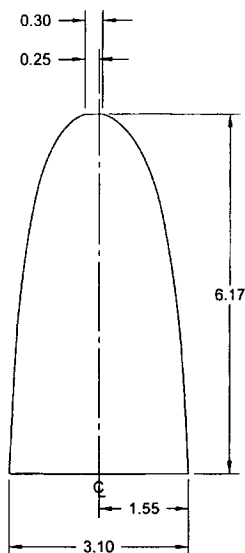
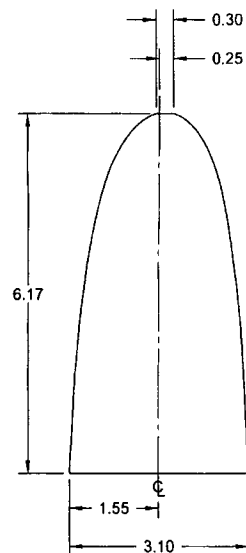
D3484-4 FACE
(MAKE FROM D3484-3F)

NOTES:

- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

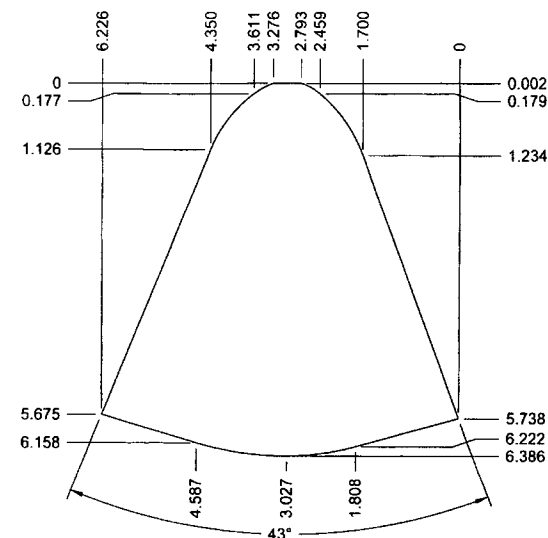
RELEASED
09/07/21/WP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3484	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:1
DATE	09.03.31	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3484-5 CONE
(MAKE FROM D3484-5F)

D3484-6 CONE
(MAKE FROM D3484-5F)



D3484-5F CONE FLAT PATTERN

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.11 lbs

RELEASED
01/04/24

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3484	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:2
DATE	09.03.31	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31473

Purchase Order Date 2/24/2016 10:31:58 AM
PO Print Date 2/24/2016

Page Number 1 of 2

Order From :

VC-GFI001

Ship To : DART AEROSPACE LTD

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
FEB 24 2016

Contact Name

Vendor Phone 514 630 4877

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3484-041P AS PER DWG D3484 REV.F B141999	Tail light Fairing	3/17/2016 Yes 3/17/2016		10.00 Each	\$280.00	\$2,800.00
Line Total:							\$2,800.00
2	D3628-1P AS PER DWG D3628 REV. C B142000	Cupped Washer	3/17/2016 Yes 3/17/2016		250.00 Each	\$2.42	\$604.00
Line Total:							\$604.00

Note:

2/24/2016



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Limitée / GFI is a division of Thomas & Betts Limited



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO.	PAGE
JR - DY	MO - MO	AN - YR		
24	03	16	0577546	1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA
DART	GFI-0299	PO31473	
QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO.	DESCRIPTION	
10	D3484041P	TAIL LIGHT FAIRING	
		ITEM 1 C OF C REQ'D FAI REQ'D	
MFG. JOB# 0314590 - 001 QTY 10 pcs			
DUE DATE: 20 March 2016			

SP160331

REÇU PAR / RECEIVED BY

DATE

EXPÉDITEUR / SHIPPER

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 12 OUR JOB NO 0314590 SHIPPING MEMO 0577546

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	10 PCS	PO31473	D3484041P	F	TAIL LIGHT FAIRING	F
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
AL 6061-T0 (AMS-QQ-A-250/11)		SAMUEL/ KAISER ALUMINUM		693598A5		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	N/A
2	WELD FOLOWING PARTS TOGETHER PER DART QSI 004(1) D3484-1 (BASE LH),(1) D3484-3 (FACE LH),(1) D3484-5 (CONE LH)	GFI	N/A
3	REF. GFI MANUFACTURING JOB NUMBER 0314590-001 (10 PCS)		
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 24 MARCH 2016

G.F.I. Q.C. REP.

Salvatore
8
800-1100-2000



LES METAUX SPECIALISES SAMUEL
21525 CLARK-GRAHAM
BAIE D'URFE, QUEBEC, CANADA
H9X 3T5

No 003506211



(514) 457-3399 TÉLÉC (514) 457-9393

PAGE 1 DE/OF 1

TRANSPORTEUR/CARRIER NAME CASTERO R-571041-4	CAMION/TRUCK 099	NOM DE LA BRANCHE/SALES BRANCH NAME SAMUEL & FILS & CIE LTÉE	DATED'EXP'DATE OF SHIPMENT 3/10/15
---	---------------------	---	---------------------------------------

VENDU À/SOLD TO: GFI, DIVISION DE THOMAS & BETTS LTEE 180 LABROSSE POINTE-CLAIRE QC H9R1A1 (514) 630-4877	EXPÉDIÉ À/SHIP TO: FAB: DEST GFI INC. 180 LABROSSE POINTE-CLAIRE QC H9R1A1 CA (0201009-00001)
--	--

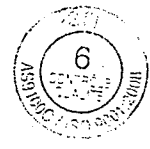
N° COMMANDE N° ITEM	DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT						
321918-01	#Comm du client: 85610 2 PC ALUMINUM 6061-0 MF SHEET .0500"x48"x144" AMS-QQA-250/11				Cert/Test: AVAIL 69 LVR		
	#Pièce AS05148144PM						
	Description	PCS	Pd ca	Oté	#PLT	#Étiq	VendeurOrg
	#Étiq min	# levée				Étiq.orig#Coul	
		2	96.000	69	291984	0700211	017 US
						31 KG	
	1804308					D880153	693598A5
	Total:	2	96.000	69			

CHARGEMENT DOIT ÊTRE TOLLÉ

Poids total: 69 LVR
Poids total: 31 KG
#Total paquets: 1

Commentaires connaissance:
CERTIFICATE OF COMPLIANCE MEETS
THE MATERIAL DETAILED ABOVE MEETS YOUR ORDER
REQUIREMENTS AND GRADE STANDARDS AS DESCRIBED
PLEASE REFER TO MILL TEST REPORT ATTACHED.
AUTHORIZED BY:

elaine Date 3/10/15
Anne Rainone
Administration



PRÉPAYÉ PAR ☒ PORTPAYÉ/PAYD ☐ PORT D'OCCECT ☐	INST. VOITURIER/DRIVER INSTRUCTIONS	VALEUR (€2000b max à moins d'avis contraire) VALUATION (Max €2,000b unless otherwise stated) VALUER DÉCLARÉE DE L'EXPÉDITION DECLARED VALUE OF SHIPMENT
EXPÉDITEUR/DISPATCHER	VOITURIER/DRIVER	REÇU PAR/RECEIVED BY

SHIP TO: SAMUEL BAIE D'URFE(SHIP TO) 21525 CLARK-GRAHAM BAIE D'URFE, PQ, CA H9X 3T5
SOLD TO: SAMUEL LAVAL 2225 FRANCIS HUGHES LAVAL, PQ, CA H7S1N5

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
 Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
 4340798

CUSTOMER PO NUMBER: C68706		WORK PACKAGE:	CUSTOMER PART NUMBER:		SHIP RUN/LOAD: 102969/9	GOV'T CONTRACT NUMBER:
KAISER ORDER NO: 1174225	LINE ITEM: 2	SHIP DATE: 22-JUL-2014	ALLOY: 6061	CLAD: BARE	TEMPER: O	PRODUCT DESCRIPTION: HT Flat Sheet
WEIGHT SHIPPED: 8461 LB	QUANTITY: 247 PCS EST.	TRUCK B/L #: 2048971	GAUGE: 0.0500 IN (1.2700 MM)	DIAMETER/WIDTH: 48.000 IN (1219.2 MM)	LENGTH: 144.000 IN (3657.6 MM)	

MHU 1799225: LOT 678063A9: 23 pieces; **D280152.**

MHU 1804308: LOT 693598A5: 112 pieces; **S3.**

MHU 1804317: LOT 693598A5: 112 pieces; **S4.**

Certified Specifications

AMS 4025/RevL
 CMMP 025/RevU

ASTM B 209/Rev10

CMMP 019/RevD

Test Code: 1925

Test Results

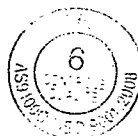
Lot: 678063A9 Cast 028 Drop 95 Ingot 2 Melted in USA

(ASTM E8/B557)
 (EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	O	LT / 2 (Min:Max)	18.6 : 18.8 (128 : 130)	7.4 : 7.5 (51 : 52)	24.0 : 24.6
	T42	LT / 2 (Min:Max)	35.7 : 36.3 (246 : 250)	17.1 : 17.6 (118 : 121)	24.6 : 25.4
	T62	LT / 2 (Min:Max)	47.9 : 48.9 (330 : 337)	41.2 : 42.3 (284 : 292)	12.9 : 13.1

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.70	0.5	0.31	0.09	1.1	0.19	0.08	0.02	0.01	0.00	TOT 0.04



KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4340798

Lot: 693598A5 Cast 029 Drop 92 Ingot 1 Melted in USA

(ASTM E8/B557)
(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	O	LT / 2 (Min:Max)	19.0 : 19.1 (131 : 132)	7.6 : 8.7 (52 : 60)	23.8 : 24.0
	T42	LT / 2 (Min:Max)	37.2 : 37.5 (256 : 259)	18.3 : 18.9 (126 : 130)	22.2 : 23.1
	T62	LT / 2 (Min:Max)	48.0 : 48.1 (331 : 332)	40.7 : 41.1 (281 : 283)	13.1 : 13.4

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.73	0.5	0.30	0.10	1.1	0.19	0.07	0.03	0.01	0.00	TOT 0.06

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
6061												
MIN(wt%)	0.40	0.0	0.15	0.00	0.8	0.04	0.00	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

TEST NOTES

6061 sheet or plate certified to AMS 4025, AMS 4026, or AMS
4027 also meets applicable requirements of AMS-QQ-A-250/11,
Rev. A.

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser), is ISO 9001:2008/AS9100C certified and hereby certifies that all material shipped under this order:

- * has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements.
 - * was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content.
 - * has been thermally processed in compliance with AMS 2772, where applicable.
 - * is mercury free, within the limits of detection of ASTM E1251 (< = 1ppm).
 - * is in compliance with RoHS 2, European Union Directive 2011/65/EU.
 - * is in compliance with and regularly monitors any updates to the European Chemical Agency, ECHA, REACH regulations, (EC) n°1907/2006.
 - * is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.
- Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on this certificate may be punished as a felony under federal law.

James Hemenway

JAMES HEMENWAY, LABORATORIES SUPERVISOR





180 Labrosse Av.
Pointe Claire, QC
H9R 1A1

TO:

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

(CPO) PO#:

PO31473



(POI) ITEM#:

0001



PACKAGE COUNT:

1 OF 1

(PNR) PART NUMBER:

D3484041P



(SHQ) QUANTITY:

10



PACKAGE WEIGHT:

(UNT) UNIT OF MEASURE:

EA



(PSN) PACKING SLIP #:

0577546



(COO) ORIGIN:

CA



(NAF) NAFTA:



(TRA) TRACEABILITY #:

0314590-001

